

# Work Order ID 81348

March-13-12 1:36:06 PM

**\*81348\***

Page 1

Item ID: D3508-13 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearplate  
 Start Date: 13/03/2012 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 27/03/2012 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/13 Tooling: Date:  
 QC: Date: SPC (Y/N): Date:  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3508	Rev C								

100 0.00  
**\*100\*** FLOW WATER JET  
 Waterjet Memo 0.00  
 FLOW CNC Waterjet 1-Cut as per Dwg D3508 Dwg Rev: C Prog Rev: C 2-  
 Debur if necessary  
302-040 12

110 0.00  
**\*110\*** QC2- Inspect parts off machine FAI/FAIB  
 QC Memo 0.00  
 Quality Control 12-3-29

120 0.00  
**\*120\*** QC8- Inspect parts - second check  
 QC Memo 0.00  
 Quality Control 5/13/12 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D3508-13

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Wearplate

Stop **\*NS2\***

Start Date: 13/03/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	1-Form on brake using DT8326 and DT8261 as per Dwg D3508								
140	QC5- Inspect part completeness to step on W/O	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
150		0.00							
<b>*150*</b>	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld hardcoat as per dwg D3508 QSI004Hardcoat 2059b Batch:								

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**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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**\*81348\***

Page 4

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Item ID: D3508-13

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Wearplate

Stop **\*NS2\***

Start Date: 13/03/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

QC3- Inspect Part Finish

0.00

**\*190\***

QC

Memo

0.00

Quality Control

12 ~~12~~ 12/04/05

200

Identify as per dwg & Stock Location **FP2**

0.00

**\*200\***

Packaging

Memo

0.00

Packaging

12 ~~12~~ 12/04/05

210

QC21- Final Inspection - Work Order Release

0.00

**\*210\***

QC

Memo

0.00

Quality Control

12/4/15

12-04-5

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**NOTE:** Date & initial all entries



# Picklist Print

March-13-12 1:36:11 PM

Page 1

Work Order ID: 81348

**\*81348\***

Parent Item: D3508-13

**\*D3508-13\***

Parent Item Name: Wearplate

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07.06.12 EC  
IPP Rev:B Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	163.6165	0.172	2.172632			

**\*M304S20GA\***

304/316 .040 Sheet

\*\*

1812-3-29

Location

Loc Qty

Loc Code

MAT020

163.6165

116623

0.2

117933

27.3442

118400

21.1723

118964

36.5

119346

29.8

120604

48.6

120604

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Dart Aerospace Ltd

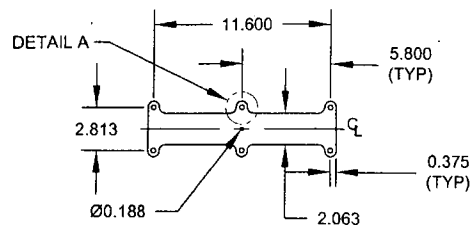
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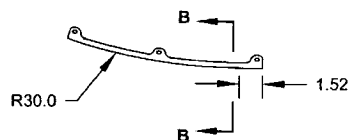
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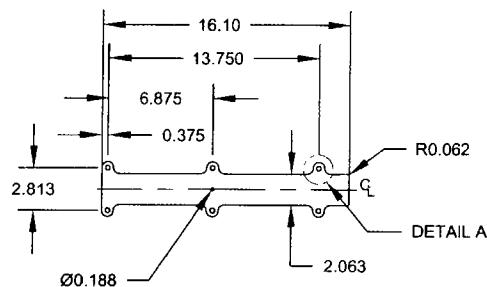
**NOTE:** Date & initial all entries



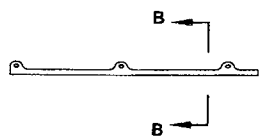
**D3508-1 FLAT PATTERN**



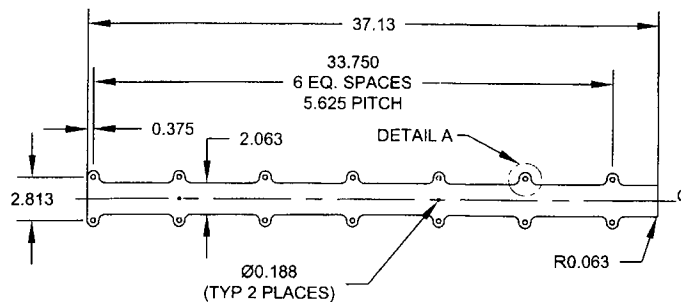
**D3508-1 BENDING DETAIL**  
(MAKE FROM D3508-1F)



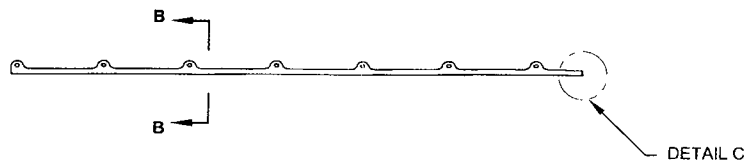
**D3508-7F FLAT PATTERN**



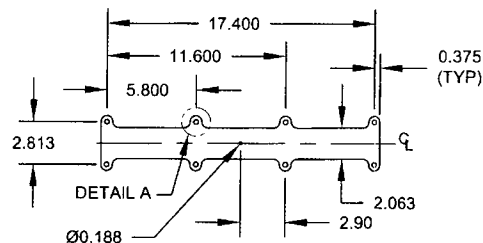
**D3508-7F BENDING DETAIL**  
(MAKE FROM D3508-7F)



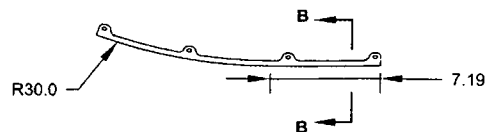
**D3508-3 FLAT PATTERN**



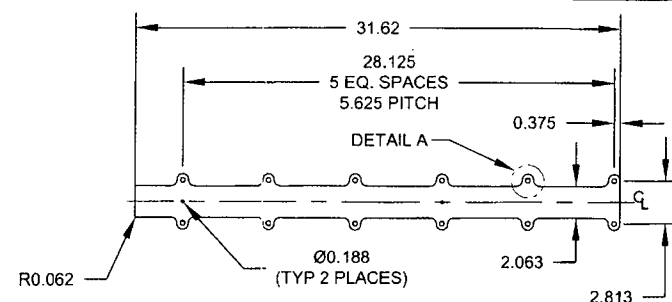
**D3508-3 BENDING DETAIL**  
(MAKE FROM D3508-3F)



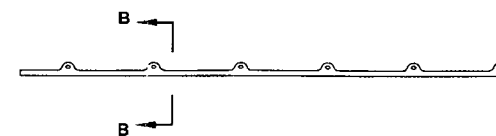
**D3508-9F FLAT PATTERN**



**D3508-9F BENDING DETAIL**  
(MAKE FROM D3508-9F)



**D3508-5 FLAT PATTERN**



**D3508-5 BENDING DETAIL**  
(MAKE FROM D3508-5F)

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,  
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs  
D3508-13 - 0.25 lbs

**RELEASED**  
07/11/16

C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.04.20		

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA

DRAWING NO. D3508  
REV. C  
SHEET 1 OF 2

TITLE WEARPLATE  
SCALE 1:8

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SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 81348 MLJ  
12/03/13

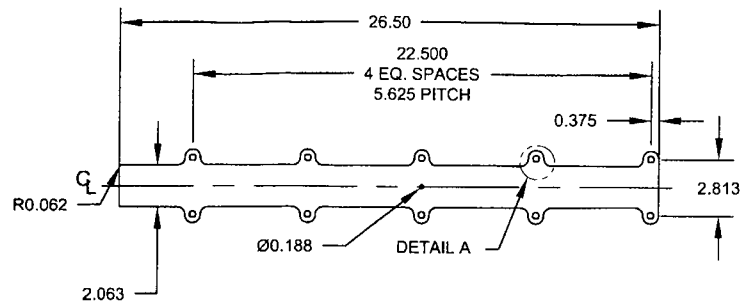
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

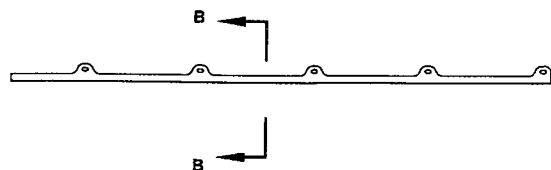
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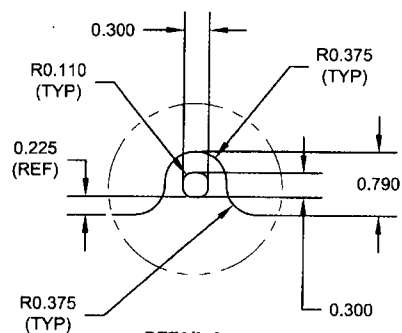
**NOTE:** Date & initial all entries



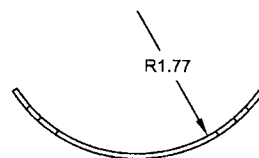
**D3508-11F FLAT PATTERN**



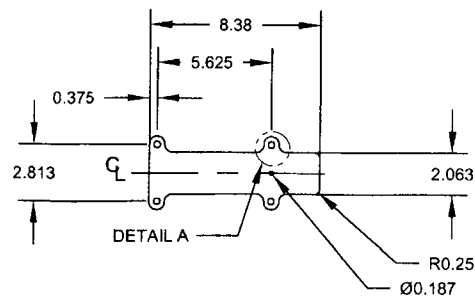
**D3508-11 BENDING DETAIL**  
(MAKE FROM D3508-11F)



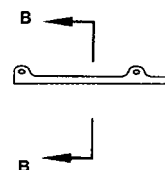
**DETAIL A**  
(SCALE 2:3)



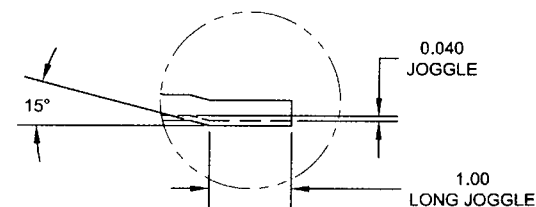
**SECTION B-B**  
(SCALE 2:3)



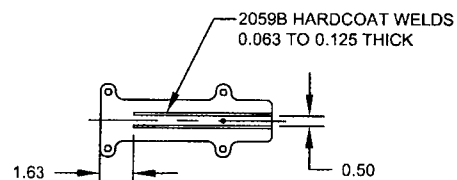
**D3508-13F FLAT PATTERN**



**D3508-13 BENDING DETAIL**  
(MAKE FROM D3508-13F)



**DETAIL C**  
(SCALE 1:2)



**D3508-13 WELDING DETAIL**

01348

RELEASED  
07.11.16

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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